



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3010
Job Sheet 204803



Part No: 646.3010

Job Qty: 30 pcs

Part Name: LH Half



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/20/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 2/17/20

Description:

Type: Stock

Note: DWG REV N/C SHEETS 2,6,7 IPP REV:A NEW ISSUE 13/01/14 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	30 pcs		2/17/20	0.00	0.69	Bandsaw - 1		ALA
110	HAAS 4 Axis - B4B	30 pcs		2/17/20	0.23	23.44	HAAS - 1 - B4B		
							HAAS - 2 - B4B <i>HAAS - 2 B4B ALA</i>		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	30 pcs		2/17/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

20/04/2

20/04/2

20/04/2



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S268524



Part: 646.3010

Job No: 204803

Serial No/Batch: S268524

Revision: Rev NC1

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/02/20

Plex 12/20/19 8:25 AM Dart.Renwick.Jennifer

					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
130	QC 8	30 pcs	2/17/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
140	Outsource - 4 - Anodize	30 pcs	2/17/20		ATG001-VC	14
150	Packaging 2-1 - Receive - B4B	30 pcs	2/17/20	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 -	

JRS 20/14/14

2/2/2020-04-07

NE APR 28 2020

						B4B	
						Packaging 2 - 17 - B4B	
						Packaging 2 - 18 - B4B	
						Packaging 2 - 19 - B4B	
						Packaging 2 - 20 - B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	
						Packaging 2 - 31 - B4B	
						Packaging 2 - 32 - B4B	
						Packaging 2 - 33 - B4B	
						Packaging 2 - 34 - B4B	
						Packaging 2 - 35 - B4B	
						Packaging 2 - 36 - B4B	
						Packaging 2 - 37 - B4B	
155 QC 6	30 pcs	2/17/20	0.00	0.00		QC 6 - 9	
						QC 6 - 68	
						QC 6 - 61	
						QC 6 - 40	DAS JUN 05 2020 40
						QC 6 - 81	9-89
180 Packaging 3-1 - Stock - B4B	30 pcs	2/17/20	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	DAS 28
						Packaging 3 - 6 - B4B	9-89
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	

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				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA		30 pcs	2/17/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS
21
9-88

JUN 08 2020

Part Op 100 - Bandsaw1 (Bandsaw) Cut Blank at 9.700"

Descriptions: 110 - HAAS1-1 (HAAS CNC Vertical Machine) 1-Machine per folio FB158 DWG REV: N/A FOLIO

REV: AA 2- deburr and break all sharp edges

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - QC8 Machining-1 (QC8- Inspect parts - second check)

140 - Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 46239 Hard Black Anodize and Prime as per Dwg 646.3000

150 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs)

155 - QC6 (QC6- All purchased or subcontracted products)

180 - Packaging3-1 (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M7075T6S6.000X0.250	7075-T6S Sheet 6" Thick Plate X 0.25" Wide	24 ft (.8 ea)	100-Bandsaw - 1	S255558 11pc S246096 19pc	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M7075T6S6.000X0.250	24	1	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	LH Half	0.250inches ± 0.005	0.255 0.245	Product	.247
2	LH Half	0.050inches ± 0.005	0.055 0.045		.048
3	LH Half	0.200inches ± 0.005	0.205 0.195		.201
4	LH Half	0.109inches ± 0.005	0.114 0.104		.111
5	LH Half	9.536inches ± 0.005	9.541 9.531		9.536
6	LH Half	8.898inches ± 0.005	8.903 8.893		8.898
7	LH Half	0.625inches ± 0.005	0.630 0.620		.626
8	LH Half	1.300inches ± 0.005	1.305 1.295		1.300
9	LH Half	5.317inches ± 0.005	5.322 5.312		5.316
10	LH Half	0.400inches ± 0.005	0.405 0.395		.399
11	LH Half	0.956inches ± 0.005	0.961 0.951		.955
12	LH Half	8.263inches ± 0.005	8.268 8.258		8.261
13	LH Half	9.150inches ± 0.005	9.155 9.145		9.150
14	LH Half	0.213inches ± 0.005	0.218 0.208		.215
15	LH Half	0.250inches ± 0.005	0.255 0.245		.250
16	LH Half	3.172inches ± 0.005	3.177 3.167		3.173
17	LH Half	4.860inches ± 0.005	4.865 4.855		4.859

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~~11 piece = S246096~~

11 piece = S255558 → scrap 0.464.

19 piece = S246096 → scrap 0.6875

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046239



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046239

PO Date: 4/7/20

Due Date: 4/22/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-04-13

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	208855	646.9715	646.9700 Rev H	Body : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1), Issue P/O to: Hard Black Anodize Color Black and Prime as per Dwg 646.9700	Firmed X4	-	4/13/20	4 pcs	0 pcs	4 pcs	\$16.86/pcs	\$67.44
									APR 14 2020			
2	208851	647.1515	647.1500 Rev E	Upper Deflector : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed X4	-	4/13/20	4 pcs	0 pcs	4 pcs	\$14.41/pcs	\$57.64
									APR 14 2020			

Plex 4/13/20 10:17 AM Dart.Guerin.Kimberley



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PURCHASE ORDER

POHB046239



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	208610	649.4811	649.4800 Rev E	Clip : Various STC's Issue P/O: AS PER MPP- 172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP- 172 SECTION 4.2, PRIME AS PER IAW MIL- PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed X4	-	4/13/20	4 pcs	0 pcs	4 pcs	\$11.96/pcs	\$47.84
4	204803	646.3010	646.3000 Rev NC1	LH Half : Various STC's Outsource4 (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 646.3000	Firmed X30	-	4/22/20	30 pcs	0 pcs	30 pcs	\$12.61/pcs	\$378.30

APR 14 2020

APR 28 2020

DAS
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046239



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	203837	647.3911	647.3900 Rev C2	212 Upper Deflector Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 1- Black Anodize as per Dwg 647.3900 2- PRIME AS PER DWG, SEE NOTE #9 Certification of Conformity is required	Firmed X11	-	4/22/20	11 pcs	0 pcs	11 pcs	\$26.86/pcs	\$295.46
											APR 28 2020	
											Grand Total:	\$846.68

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A04 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/13/20 10:17 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920019

Date: 21-Apr-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
30 ea	Part: 646.3010 LH Half Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5236137 Job: 27304 PO: POHB046239	Rev: NC	DAS 40 9-89
11 ea	Part: 647.3911 212 Upper Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .006-.0009" (1.2 mils) per drawing Batch/Lot#: 5236137 Job: 27305 PO: POHB046239	Rev: C2	Expiry Date: 05/29/2021 Line: 4
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: APR 21 2020 Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Made in Canada.			

REC'D
APR 28 2020
DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920019

Date: 21-Apr-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		ATG Delivery
Quantity	Description	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
Made in Canada.		